



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-1027-251
Job Sheet 190572



Part No: D135-1027-251

Job Qty: 1 pcs

Part Name: Std Height Aft Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: D135-1027-251 REV.D IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM IPP REV:B 17.12.14 AS PER DWG
REV.C DD VERF:JFS IPP REV:C 18.11.09 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Handfinish - 1 - Chemical	1 pcs	3/29/19		0.00	0.17	Handfinish - 1 - 1	
							Handfinish - 1 - 2	
							Handfinish - 1 - 3	
							Handfinish - 1 - 4	
							Handfinish - 1 - 5	
							Handfinish - 1 - 6	
							Handfinish - 1 - 7	
							Handfinish - 1 - 8	
							Handfinish - 1 - 9	
							Handfinish - 1 - 10	
							Handfinish - 1 - 11	
							Handfinish - 1 - 12	
							Handfinish - 1 - 13	
							Handfinish - 1 - 14	
							Handfinish - 1 - 15	
							Handfinish - 1 - 16	
							Handfinish - 1 - 17	
							Handfinish - 1 - 18	
							Handfinish - 1 - 19	
							Handfinish - 1 - 20	
							Handfinish - 1 - 21	
							Handfinish - 1 - 22	
105	QC 7	1 pcs	3/29/19		0.00	0.00	QC 7 - 10	
							QC 7 - 13	
							QC 7 - 14	
							QC 7 - 15	
							QC 7 - 17	
							QC 7 - 18	
							QC 7 - 19	
							QC 7 - 2	



Container No: S164536



Part: D135-1027-251

Job No: 190572

Serial No/Batch: S164536

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/21/19

Plex 3/15/19 4:12 PM Dart.Hadley.Shannon

SCRAP
P.T.O.

					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	TW
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
110	Purchasing	1 pcs	3/29/19	0.00 0.00	Purchasing - 1	03/21/2019 PL
	DAS 10 Outsource 23				Purchasing - 2	
					Purchasing - 3	
120	Packaging 2-1 - Receive - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 2 - 1 - B4B	
	✓				Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	TW 19-03-21
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
130	QC 6	1 pcs	3/29/19	0.00 0.00	QC 6 - 42	
					QC 6 - 9	19-03-27

132	Crosstubes - 2 - B4B	1 pcs	3/29/19	0.00 1.00	QC 6 - 68	
					QC 6 - 61	
					Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
135	QC 15	1 pcs	3/29/19	0.00 0.00	Crosstubes - 4 - B4B	
					QC 15 - 12	
					QC 15 - 3	
					QC 15 - 47	
					QC 15 - 49	
140	Outsource	1 pcs	3/29/19	0.00 0.00	QC 15 - 58	
					QC 15 - 9	
					SKY002-VC	5
150	Packaging 2-2 - Receive - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160	QC 6	1 pcs	3/29/19	0.00 0.00	QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
170	Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - FG	1 pcs	3/29/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 100 - (Chemical Conversion Coat per QSI005 4.1) Alodine prior to sending the extrusion to an outside vendor.
 Descriptions: 105 - (QC7-Inspect Chemical Conversion Coat)
 110 - Issue P/O to Tube Caron: _____ Manufacture D135-1027-251 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6026-110** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required
 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material release note is attached
 130 - (QC6- All purchased or subcontracted products)
 132 - (Crosstube Grinding Booth) REMOVE ALL MARK AS PER DWG
 135 - (QC15- Crosstube Dimensional Check)
 140 - ISSUE P/O: _____ C OF C IS REQUIRED
 150 - (Receive & Inspect for Damage & Mat'l Certs) OF C IS REQUIRED
 160 - (QC6- All purchased or subcontracted products)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6026-110	Crosstube Material	1 Ea (1 ea)	100-Handfinish - 1 - Chemical	S152384
D135-1027-251P	Std Height Aft Crosstube	1 pcs (1 ea)	120-Packaging 2-1 - Receive - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Handfinish - 1 - Chemical	D6026-110	1	24	0
120-Packaging 2-1 - Receive - B4B	D135-1027-251P	1	6	0

Part Specifications
Specifications could not be found.

Plex 3/15/19 4:12 PM Dart.Hadley.Shannon



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D135-1027-251
Job Sheet 190572



Part No: D135-1027-251

Job Qty: 1 ea

Part Name: Std Height Aft Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: D135-1027-251 REV.D IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM IPP REV:B 17.12.14 AS PER DWG REV.C DD VERF:JFS IPP REV:C 18.11.09 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/29/19	0.00	0.00	Start Up Handfinish		
100	HandFinish	1 pcs		3/29/19	0.00	0.17	HandFinish1		
105	QC	1 pcs		3/29/19	0.00	0.00	QC7-5		
110	Purchasing	1 pcs		3/29/19	0.00	0.00	Purchasing		
120	Packaging	1 pcs		3/29/19	0.00	0.00	Packaging2		
130	QC	1 pcs		3/29/19	0.00	0.00	QC6		
132	Crosstubes	1 pcs		3/29/19	0.00	1.00	Crosstube Grinding Booth		
135	QC	1 pcs		3/29/19	0.00	0.00	QC15		
140	Outsource	1 pcs		3/29/19			SKY002-VC	5	
150	Packaging	1 pcs		3/29/19	0.00	0.00	Packaging2		
160	QC	1 pcs		3/29/19	0.00	0.00	QC6		
170	Packaging	1 pcs		3/29/19	0.00	0.00	Packaging3-1		
180	QC21-FG	1 Ea		3/29/19	0.00	0.00	QC21		

Part Op 100 - Alodine prior to sending the extrusion to an outside vendor.

Descriptions: 110 - Issue P/O to Tube Caron: 042567 Manufacture D135-1027-251 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6026-110** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required

120 - Ensure material release note is attached

132 - REMOVE ALL MARK AS PER DWG

140 - ISSUE P/O: _____ C OF C IS REQUIRED

150 - C OF C IS REQUIRED

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6026-110	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	
D135-1027-251P	Std Height Aft Crosstube	1 pcs (1 ea)	120-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6026-110	1	24	0
120-Packaging	D135-1027-251P	1	6	0
Part Specifications				
Specifications could not be found.				

Plex 2/11/19 1:03 PM dart.white.jesse



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Supplier: TUB001-VC
Tube Caron Inc.
99 Louis-Joseph-Doucet Street
Lanoraie
QC
JOK 1EO Canada
Phone: 450-887-2766
Fax: 450-887-2897

PO No: PO042567
PO Date: 2/11/19
Due Date: 3/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
190567		D135-1027-253	Mid Height Aft Crosstube (Purchasing) Issue P/O to Tube Caron: Manufacture D135-1027-253 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6027-115** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00

1 X MAR 21 2019

Line Item Note REV C

190568	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
190569	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191900	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191901	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							5	0	5	\$1,500.00



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	190489	D135-1027-251	Std Height Aft Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-251 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6026-110** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. *** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00

1X MAR 21 2019

Line Item Note REV D

190571	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
190572	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191903	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191905	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191907	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							6	0	6	\$1,800.00



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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190560	D135-1027-153	Mid Height Fwd Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-153 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00

1 X MAR 21 2019

Line Item Note: REV B

190562	1 X MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
190564	1 X MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191909	1 X MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191910	1 X MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:					5	0	5		\$1,500.00



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Canada

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PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	190575	D135-1027-151	Std Height Fwd Crosstube Purchasing - Issue P/O to Tube Caron: Manufacture D135-1027-151 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Line Item Note REV D											
	190576	1	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191908	1	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							3	0	3		\$900.00

Grand Total: \$5,700.00

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

 A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

 A041 quality management system
 A042 dart notification by supplier
 A043 retention of quality documents

 A048 counterfeit parts avoidance, detection, mitigation and disposition program

 A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/21/19 12:52 PM dart.Lussier.Patrick

**SHIPPING BILL****BOL 14944****13/03/2019****Tube Caron Inc.**

99 Louis-Joseph-Doucet
Lanoraie, QC, Canada
J0K 1E0
Phone: 450-887-2766

Fax: 450-887-2897

Ship To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-1053

Fax : 613-632-4443

Sold To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-5200

Fax : 613-632-4443

Third Party Billing:

Ln	Item	Qty	Po	Job	Weight	UOM
1	PALETTE				20.00	Pounds
	D135-1027-151 REV D	1	PO042567	J21867-11	13.36	Pounds
	D135-1027-151 REV D	1	PO042567	J21867-12	13.36	Pounds
	D135-1027-151 REV D	1	PO042567	J21867-16	13.36	Pounds
	D135-1027-153 REV B	1	PO042567	J21867-10	14.57	Pounds
	D135-1027-153 REV B	2	PO042567	J21867-15	29.14	Pounds
	D135-1027-153 REV B	1	PO042567	J21867-8	14.57	Pounds
	D135-1027-153 REV B	1	PO042567	J21867-9	14.57	Pounds
	D135-1027-251 REV D	1	PO042567	J21867-5	16.21	Pounds
	D135-1027-251 REV D	1	PO042567	J21867-6	16.21	Pounds
2	PALETTE				20.00	Pounds
	D135-1027-251 REV D	3	PO042567	J21867-14	48.64	Pounds
	D135-1027-251 REV D	1	PO042567	J21867-7	16.21	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-1	19.81	Pounds
	D135-1027-253 REV C	2	PO042567	J21867-13	39.62	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-2	19.81	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-3	19.81	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-4	19.81	Pounds

Carrier:
Phone:
Way Bill:

Journey Freight
1-888-633-1252 #3221

Fob:
Freight Charges:

Fob Lanoraie
Collect

Total Of Packages :

2 PALETTES
96 X 32 X 36
96 X 32 X 36

Total Weight:

369.06 #

Carrier : Journey Freight

Shipper : Tube Caron Inc.

Declared Value : (No Additional Insurance Required)

Not Applicable For Insurance Purposes

14-03-2019

CERTIFICATE OF CONFORMANCE

CUSTOMER : Dart Aerospace

DATE : March 21, 2019

P.O.# PO042567

I certify that the following parts were manufactured to the specifications stated on the drawings listed below.

Note: Material for manufacturing of parts is provided by Dart Aerospace.

PART NO.	QTY.	DRAWING NO. / REV.
D135-1027-253 ✓ MID HEIGHT AFT XTUBE	6 ✓	D135-1027-253 / REV.C
D135-1027-153 ✓ MID HEIGHT FWD XTUBE	5 ✓	D135-1027-153 / REV.B
D135-1027-151 ✓ STD HEIGHT FWD XTUBE	3 ✓	D135-1027-151 / REV.D
D135-1027-251 ✓ STD HEIGHT AFT XTUBE	6 ✓ PD 19-03-27	D135-1027-153 / REV.D

Sincerely,

Kevin Gadoury

Kevin Gadoury

DART AEROSPACE LTD		Work Order:	190572
Description: STD HEIGHT AFT CROSSTUBE		Part Number:	D135-1027-251
Inspection Dwg: D135-1027-251 Rev: C		Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.700" TYP	+/-0.005"					
7.07" TYP	+/-0.030"					
2.17" REF	+/-0.030"					
3.13" TYP	+/-0.030"					
Ø.194" THUR 2PL	+0.006" -0.001"					
Ø.194" THUR	+0.006" -0.001"					
17.0" 2PL	+/-0.100"					
Ø.313" THUR 4PL	+0.006" -0.001"					
Ø.670" THUR 2PL	+0.006" -0.001"					

WALL THICKNESS MEASUREMENTS

LOCATION FROM CL	DWG DIM	R1	R2	R3	R4				
CL	0.177"								
21"	0.177"								
21"	0.177"								
CENTER OF BEND	0.177"								
CENTER OF BEND	0.177"								

OUTSIDE DIAMETER MEASUREMENTS

LOCATION	DWG DIM	M1	M2				
CL	3.543"						
CENTER OF BEND	3.543"						
CENTER OF BEND	3.543"						

CRUSHING

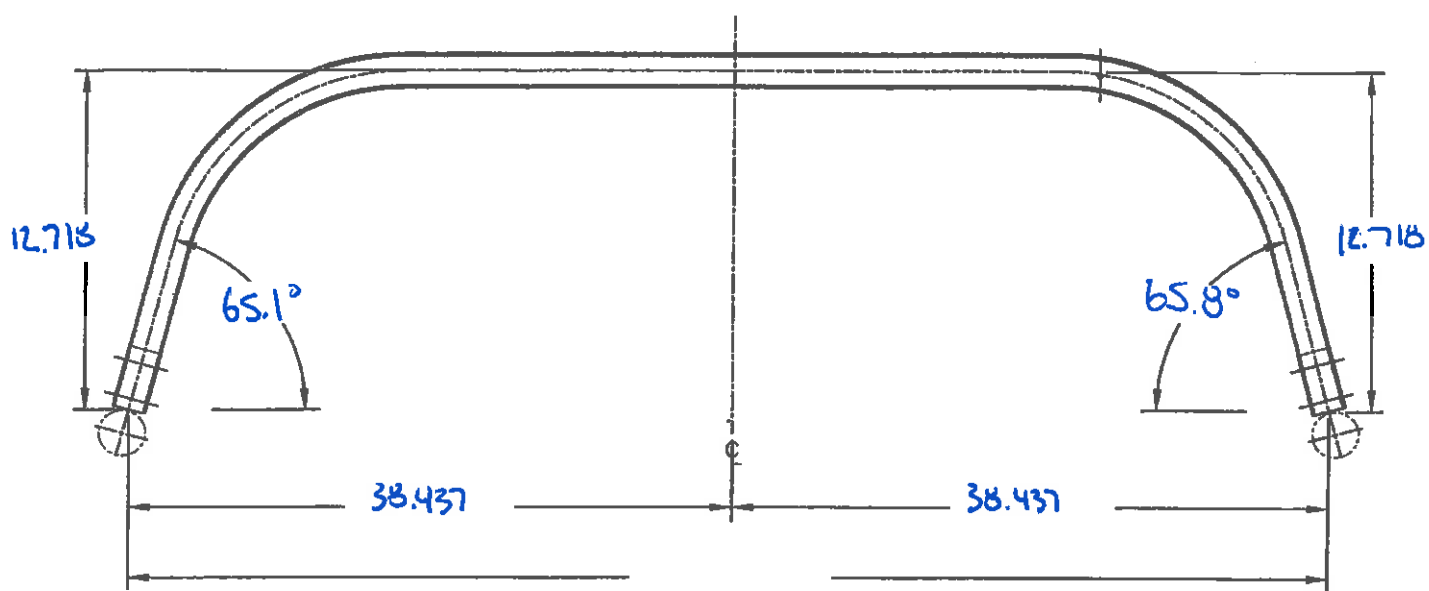
	SIDE A	SIDE B
MAX 2%	13%	1%

TWIST

	SIDE A	SIDE B
MAX 0.25"		

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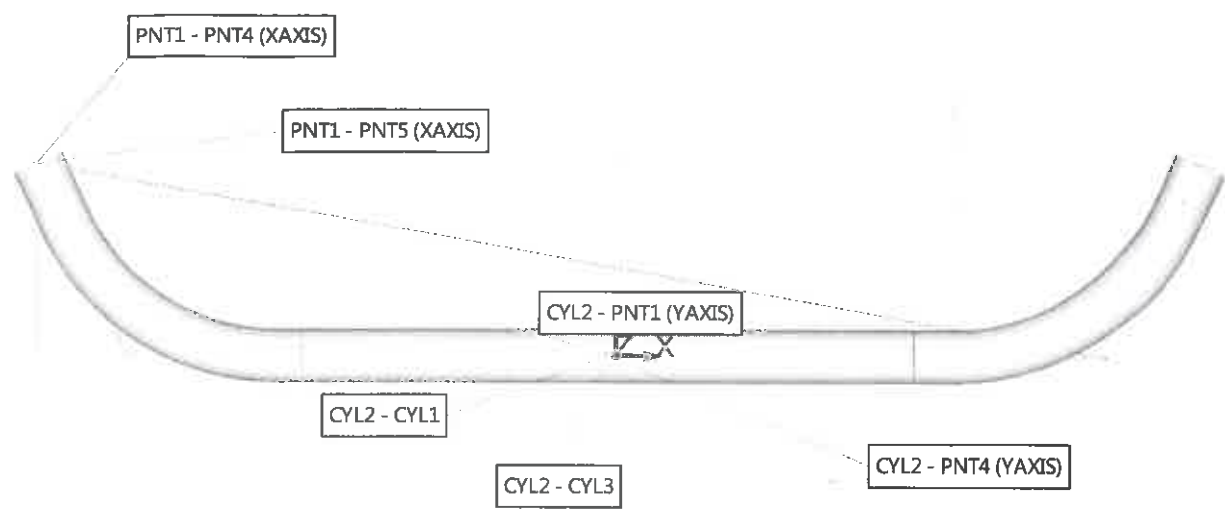
Required Dimension	Min	Max
Height	12.62"	12.88"
1/2 Span	38.35"	38.61"
Angle	64°	66°
Total Span	76.70"	77.22"
Bending Passes		
Crushing	0%	2%



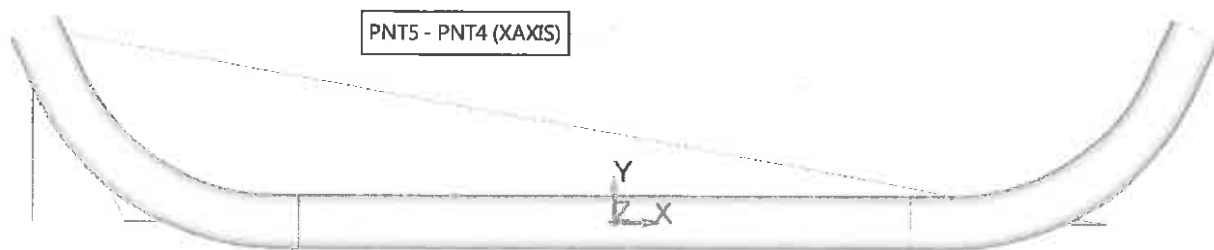
Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	18/01/16	New Issue	ED	



po-dmis		PART NAME : D135-1027-251_Pilage+Coupe				mars 09, 2019		16:02	
		REV NUMBER : Rev.C		SER NUMBER : S164536		STATS COUNT : 1			
∠		DEG	ANGL1 - CYL2 TO CYL1						
AX		NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
A		-64.9925	0.5000	0.5000	64.5717	0.4208	0.0000		
∠		DEG	ANGL2 - CYL2 TO CYL3						
AX		NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
A		64.9925	0.5000	0.5000	65.1224	0.1299	0.0000		
↔		IN	DIST1 - PNT1 TO PNT4 (XAXIS)						
AX		NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M		76.9610	0.2500	0.2500	76.9285	-0.0325	0.0000		
↔		IN	DIST2 - CYL2 TO PNT1 (YAXIS)						
AX		NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M		12.7469	0.1300	0.1300	12.6976	-0.0493	0.0000		
↔		IN	DIST3 - CYL2 TO PNT4 (YAXIS)						
AX		NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M		12.7469	0.1300	0.1300	12.7450	-0.0019	0.0000		
↔		IN	DIST4 - PNT1 TO PNT5 (XAXIS)						
AX		NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M		38.4805	0.1300	0.1300	38.4642	-0.0163	0.0000		



	IN	DIST5 - PNT5 TO PNT4 (XAXIS)				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M	38.4805	0.1300	0.1300	38.4642	-0.0163	0.0000

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>190572</u> Part No. <u>D135-1027-251</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042) <u>ND</u> <u>19.06.20</u>					
Description Work Order Deviation Ground handling hole misdrilled $\phi 0.670$ per dwg, oversize to $\phi 0.690$ min to clean up.				Disposition Highly loaded hole, not acceptable to deviate. No rework possible. Scrap.							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Completed By <u>ND</u> <u>19.06.20</u>				Lead hand / Supervisor QC / QA Coordinator <u>DAS</u> <u>68</u> <u>9-89</u> <u>AUG 02 2019</u>							